

Date:
User:Tuesday, 25/11/2008 9:53:34 AM
Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARPLATE		
Job Number	: 43723-2			Part Number	: D33191		
Estimate Number	: 10437			Drawing Number	: D3319 REV. B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 25/11/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: //	Type	: SMALL /MED FAB	Due Date	: 02/12/2008		
Previous Run	: 42513			Qty:	Splat ✓		
Written By	:			Um:	Each		
Checked & Approved By	: MF 08-11-25						
Comment	: Est: B 05.10.14 Added step 9, dwg rev B Est Rev:C Now on Waterjet 06-10-26 JLM			KJ/EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025 SHEET .048 8.1 Comment: Qty.: 0.6594 sf(s)/Unit Total : 7.9128 sf(s) 106603 X 3 = 2. 1010/1025/A21/6aA SHEET .048 4.7 109948 X 2 = 1.4 Batch: 103089x7 HB 8-11-25
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: B HB 8-11-25 Prog Rev: B 2-Deburr if necessary HB 8-11-25
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE HB 8-11-25 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary n/n Done at step #2.2 Solu/25

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Job Number: 43723		Part Number: D33191
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE	1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B 2- Form flat on press using DT8776 block	SB 08/11/26 (B)
7.0	QC6	DIMENSIONAL CHECK 
Comment: DIMENSIONAL CHECK		S 08/11/26 (43)
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1	1- Layout weld location as per Dwg D3319 using jig D3319-1T3 2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: P	SP1.L 8-11-27 (P)
Qty A/R	Part Number N/A	Description 7560 Hardcoat Rod Batch M109560
9.0	QC10	VISUAL INSPECTION OF GROUND WELDS 
Comment: VISUAL INSPECTION OF GROUND WELDS		S 08/11/27 (47)
10.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		S 08/11/27 (47)
11.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: 7:40 OVEN TEMPERATURE: 320° FINISH TIME: 8:10	M 109648 (7X) 08/11/28
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		HJ 08-11-28 (X2)

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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 PACKAGING 1

PACKAGING RESOURCE #1



7x

Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 496

8/11/28

SD

14.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/08

Comment: FINAL INSPECTION/W/O RELEASE

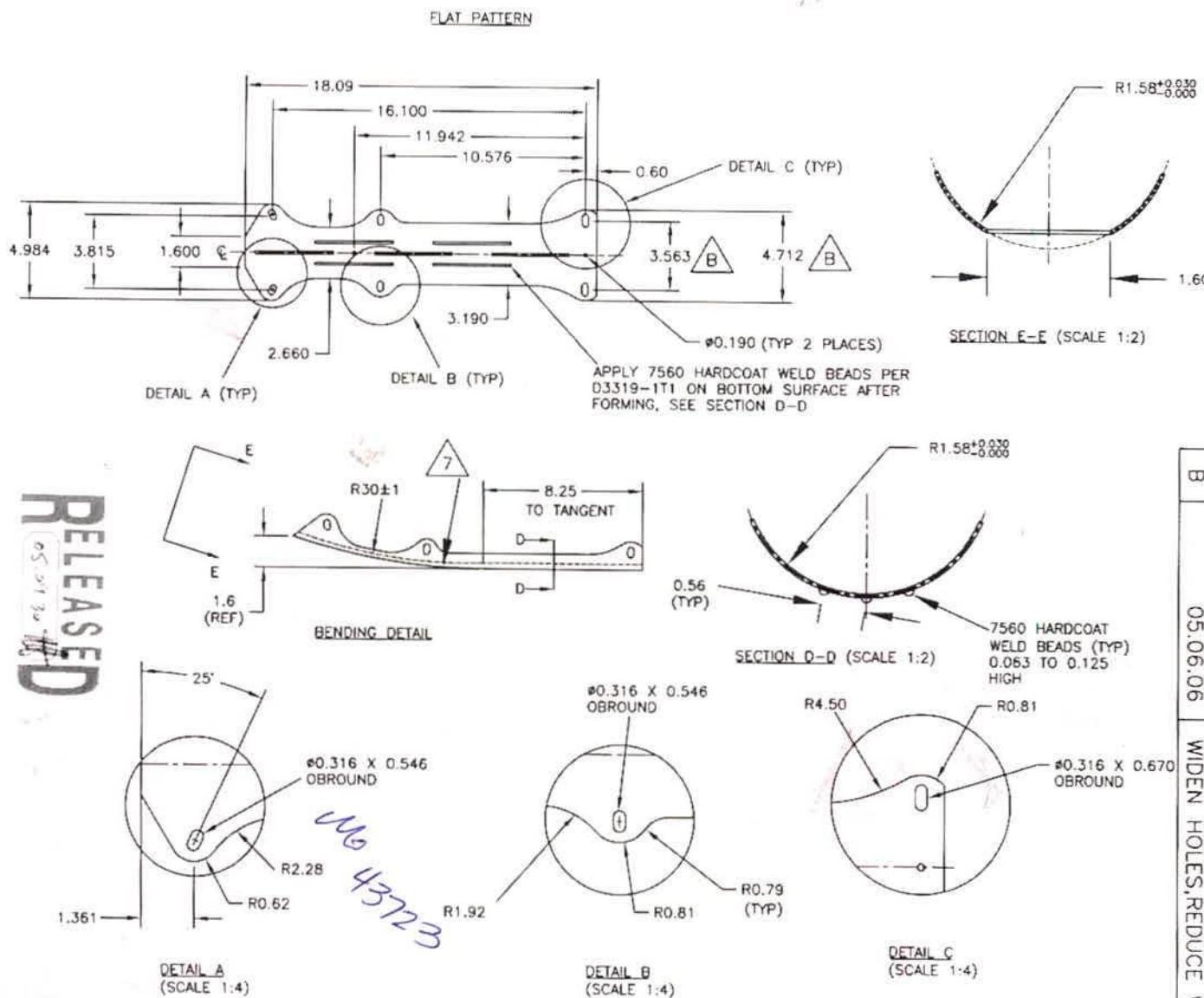
Job Completion



MF 08-11-28

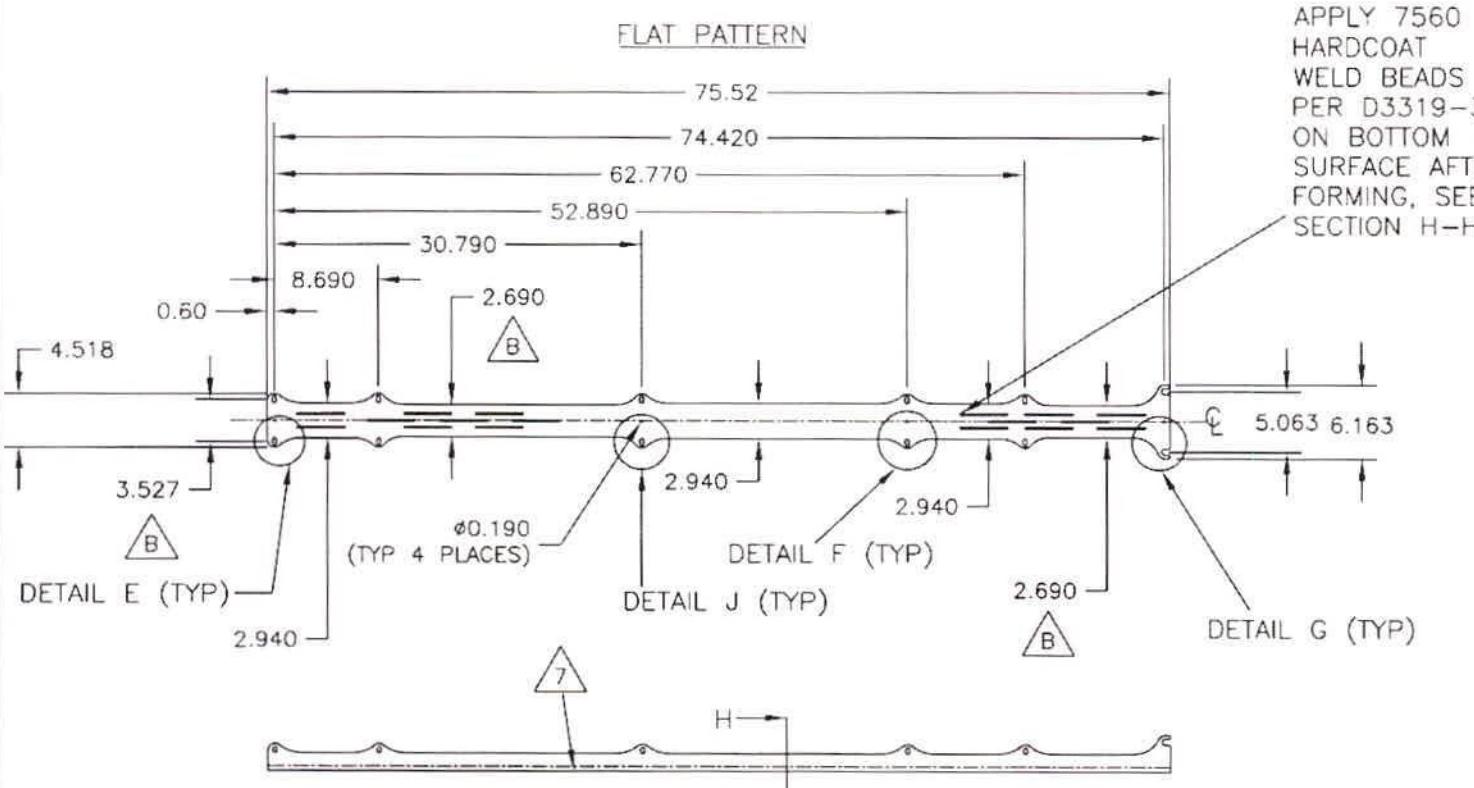
DART

DESIGN P41	DRAWN BY P41	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D 3319
DATE 05.06.06	TITLE WEARPLATE	SCALE 1.8
A B	04.09.24 05.06.06	NEW ISSUE WIDEN HOLES, REDUCE WIDTH -3/-5/-7



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

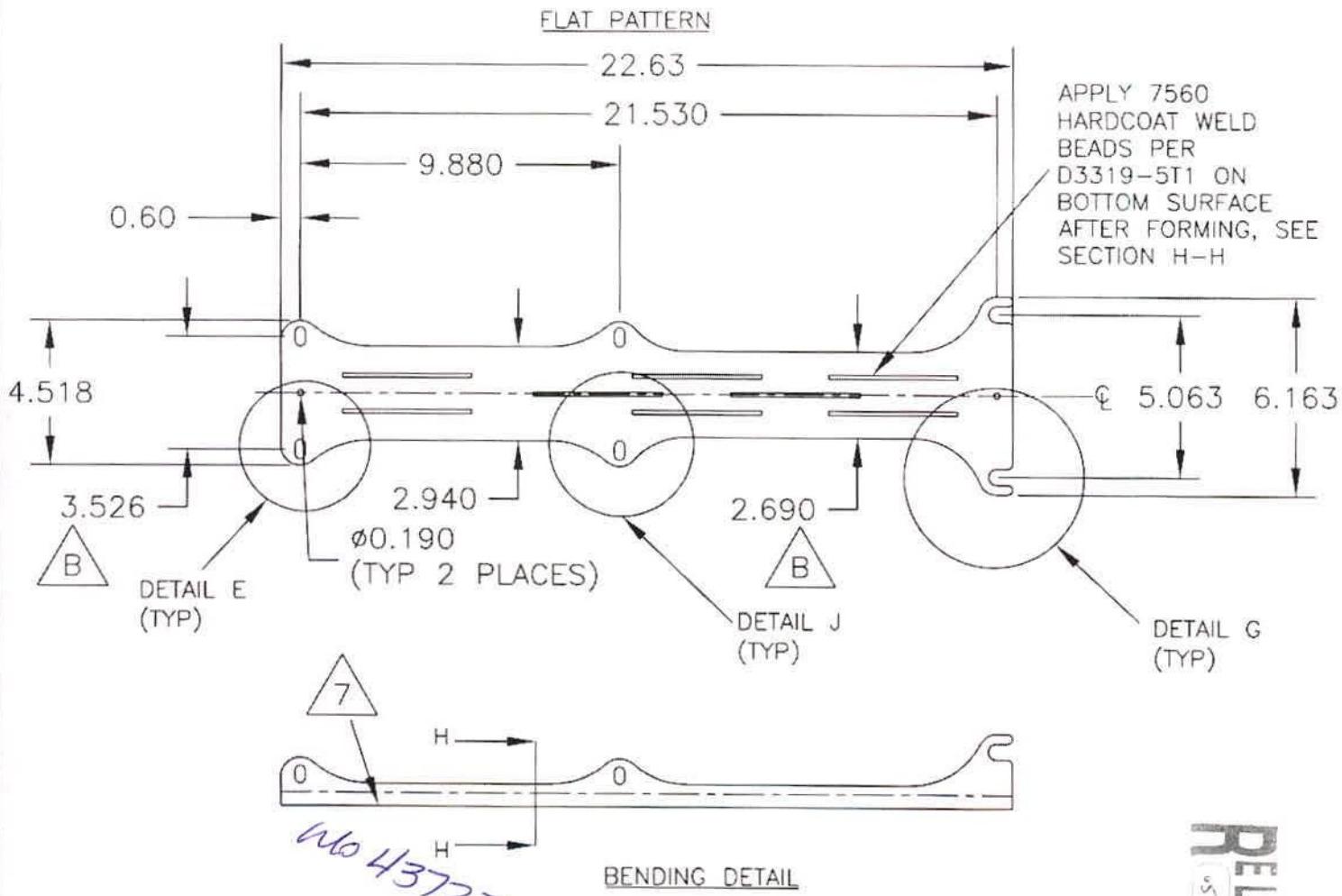
D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3319	DATE 05.06.06	TITLE WEARPLATE	REV. B SHEET 2 OF 5 SCALE 1:15

RELEASED
[Signature]



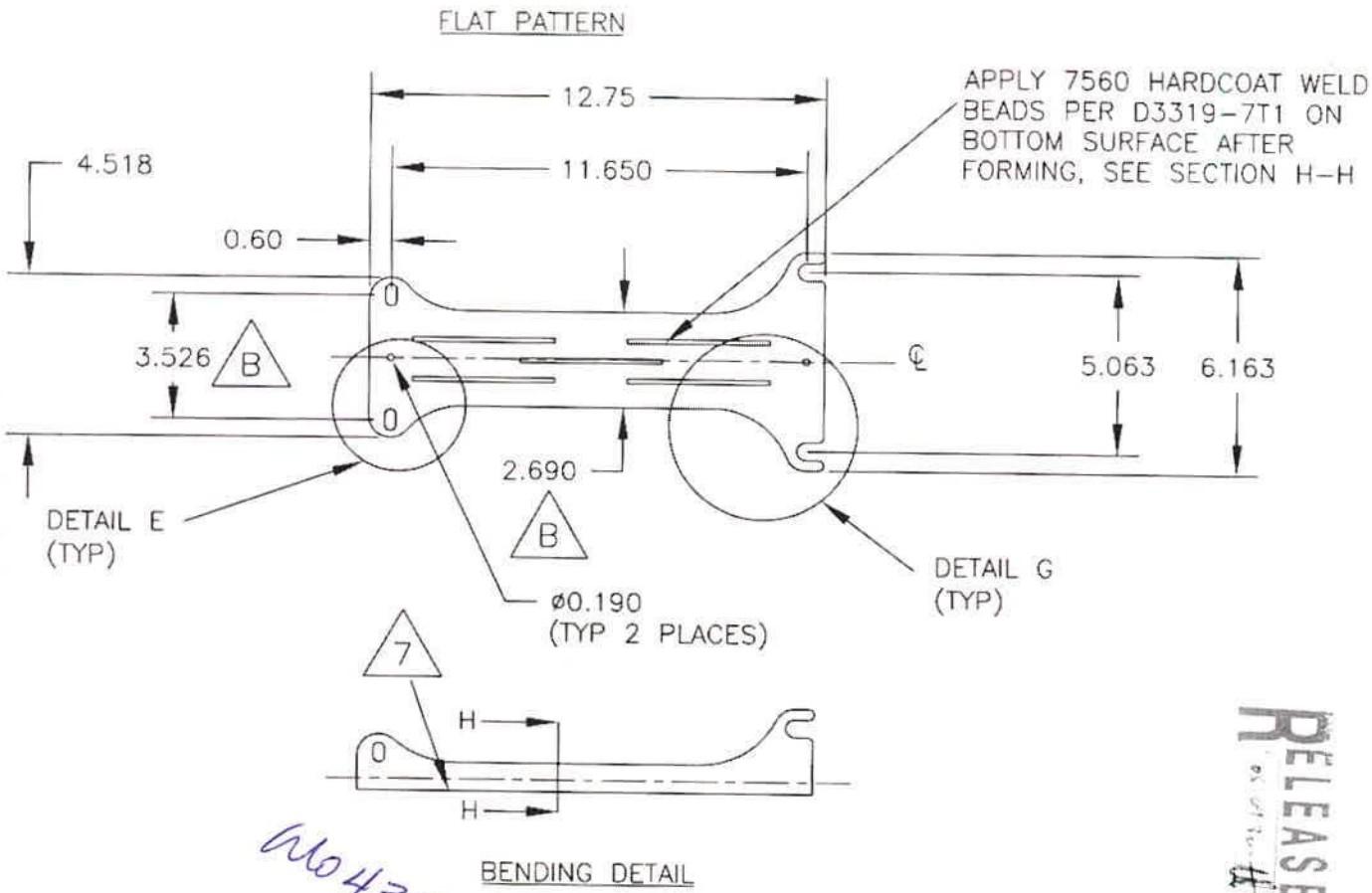
D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DESIGN <i>P41</i>	DRAWN BY <i>P41</i>	DART AEROSPACE LTD	
CHECKED <i>H</i>	APPROVED <i>H</i>	HAWKESBURY, ONTARIO, CANADA	
DATE 05.06.06	TITLE WEARPLATE	DRAWING NO. D3319	
REV. B	SHEET 3 OF 5	SCALE 1:5	

RELEASED



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

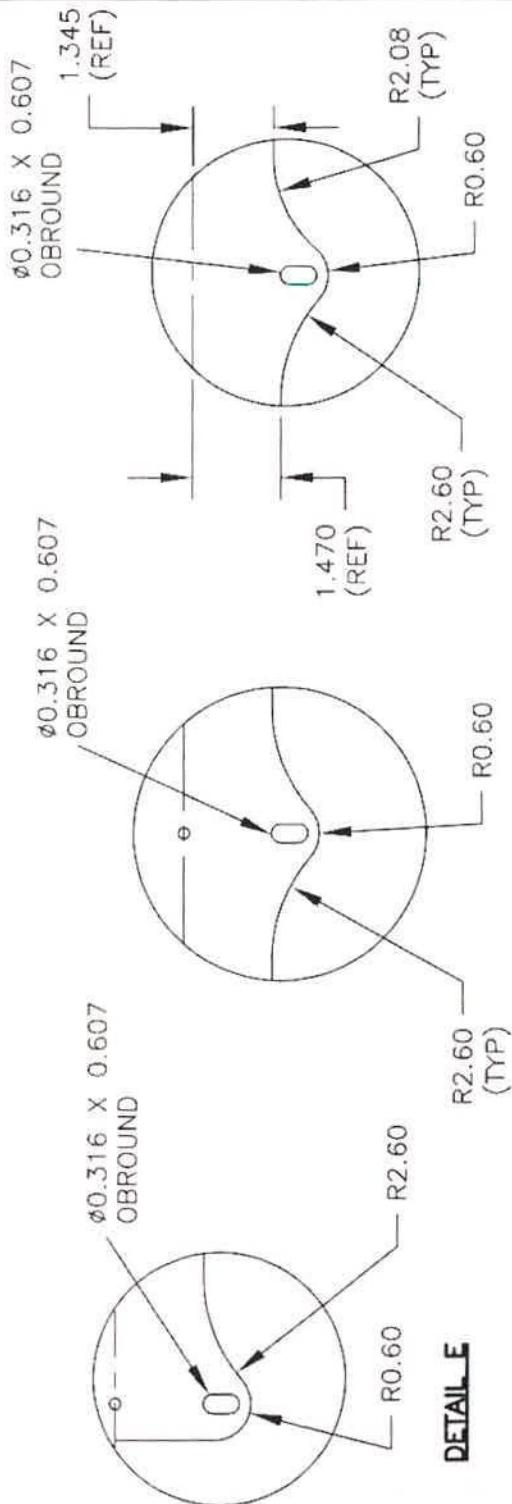
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	REV. B SHEET 4 OF 5 SCALE 1:5

RELEASED
[Handwritten signature]

DART

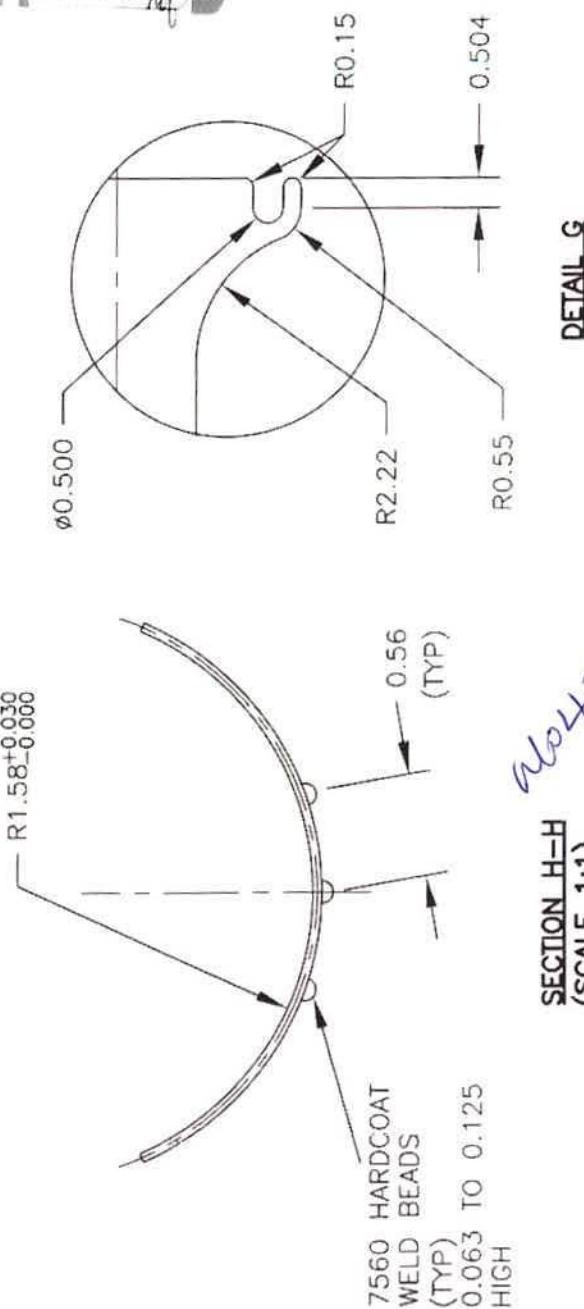
DESIGN <i>JH</i>	DRAWN BY <i>JH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3



DETAIL E

DETAIL F

RELEASED
(OS 09 30/06)



**SECTION H-H
(SCALE 1:1)**

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DART AEROSPACE LTD	Work Order:	43723
Description: Wearplate	Part Number:	D3319-1
Inspection Dwg: D3319	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	C	Prototype Approval:	N/A
Date:	8-11-25	Date:	8/16/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	<i>[Signature]</i>